Date:

Tuesday, 2/26/2008 8:02:10 AM

User:

Kim Johnston

**Process Sheet** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 37631

**Estimate Number** : 10729

P.O. Number

This Issue : 2/26/2008

Prsht Rev.

: NC

First Issue Previous Run

: // : 36749B

: SMALL /MED FAB Type

Part Number

**Drawing Name** 

**Drawing Number** 

: D23245 D2324 REV C

: STRAP

Project Number **Drawing Revision** 

: N/A : C

Material

Due Date

: 3/17/2008

Qty:

50 Um:

Each

Written By

Checked & Approved By

Comment

: Est. E 03.92.28

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

Comment: Qty.:

0.0184 sf(s)/Unit

Total:

0.9200 sf(s)

304/316 .063 Sheet

106860

304/316 .063 Sheet

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2324 Dwg Rev: \_\_\_\_\_\_\_\_

Prog Rev: C

2-Deburr if necessary

3.0

QC2



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

4.0

QC8

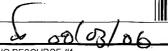
SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING





PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						1			
				11.					
		4				1			

Part No: D3345 PAR #: NA Fault Category Prod Fas pas NCR: Ves No DQA: D Date: 48/03/0

NA: N/C Closed: \_\_\_\_\_\_\_\_ Date: \_\_\_\_\_\_08\_|0

NCR:	376	3 \ W	ORK OR	DER NON-CONFORMANCE	E (NCR)	O		
DATE STED Description of NC			Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief, Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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		RC import playant on	Joseph	04(13)		्रीक्छ/do	Lower	व्विश्व
		the water Jet					1	
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NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:10 AM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STRAP Job Number: 37631 Part Number: D23245 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE 2008/3/07 Job Completion

## **Dart Aerospace Ltd**

	•								
W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•					
Part No	:	PAR #:	Fault Cateç	jory: I	NCR: Yes	No DQ	A:	Date:	
**			MODIC ODDI	D NON CONFORMAN			J:	Date:	
NCR:		100	WORK ORDE	R NON-CONFORMAN	CE (NC	≺)		ļ	
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
DATE			Initial Chief Eng	Action Description Chief Eng	Sign Date	🖔 Secti		Chief Eng	QC Inspector
					0.0				
								·	
						1.20		1-1-1	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	3763
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

ype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	.38	-			
Ø0.257	+0.006/-0.001	.259	A			140
Ø0.191	+0.005/-0.001	491.	X			
0.750	+/-0.010	r:SI	*			
0.375	+/-0.010	315	*			
1.875	+/-0.010	1,875	se.			
3.000	+/-0.010	3,000	¥			
3.375	+/-0.010	3,375	¥			
	127 - 77 - 400					
		21				

Measured by:		Audited by:		Prototype Approval:	N/A	
Date:	8-3-4	Date:	00/03/06	Date:	N/A	

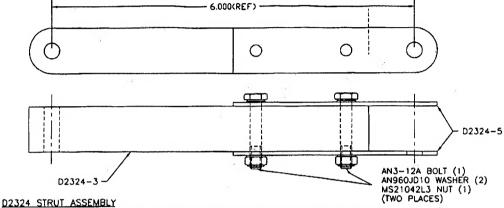
F	Rev	Date	Change	Revised by	Approved
	Α	06.06.05	New Issue	Revised by KJ/JLM	
					7.7



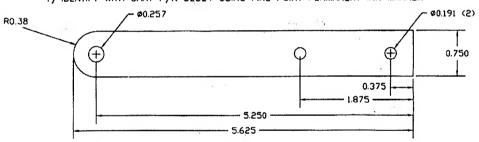
DESIGN DRAWN BY DART **AEROSPACE** VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** PH REV. C APPROVED DRAWING NO. CHECKED D2324 SHEET 1 OF 1 DATE TITLE SCALE **STRUT** 04,12,14 94.11.08 **NEW ISSUE** UPDATE MATERIALS В 96.05.07

RELEASED

C 04.12.14 UPDATE NOTES



1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:

(REF DART SPEC. M6061T6B0.750X00.750)

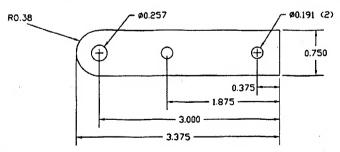
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA) 1) MATERIAL:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0:005 TO 0:015

4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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